

Date: Monday, 6/25/2007 9:10:00 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SCUFF PLATE
Job Number	: 33109	Part Number	: D206555003
Estimate Number	: 11952	Drawing Number	: D206-555 REV C
P.O. Number	:	Project Number	: N/A
This Issue	: 6/25/2007 S.O. No. :	Drawing Revision	: C
Prsht Rev.	: NC	Material	: <u>N/A</u>
First Issue	: 1/1 Type : SMALL /MED FAB	Due Date	: 7/10/2007
Previous Run	: 31604	Qty:	10 Um: Each
Written By	:		
Checked & Approved By	: <u>JA 07.06.25</u>		
Comment	: est rev C 99.06.29 returned to electro polish DM Est Rev:D Now on Waterjet 06-10-25 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Form parts on hydraulic press as per Dwg. D206-555 using DT 8316-3		<u>N/A</u> <u>JA 07-07-29</u>
2.0	M304S25GA	304/316 .020" Sheet
Comment: Qty.: 0.4148 sf(s)/Unit Total : 4.1475 sf(s) 304/316 .020" Sheet 25GA Batch: <u>M104933</u>		<u>SAD</u> <u>07/07/29</u>
3.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D206-555 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary <u>SAD</u> <u>07/07/30</u> <u>JA</u> <u>07/07/29</u>		<u>10</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<u>SAD</u> <u>07/07/29</u> <u>10</u>
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		<u>JA</u> <u>07/07/30</u> <u>810</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 6/25/2007 9:10:00 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 33109

Part Number: D206555003

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Finish form on bench forming Jig DT 8317-3

FF 07-11-14  
SB 07/11/13

(10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/11/14 (10)

8.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: 5046

Possible supplier: TQF Technologies

07/11/14 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

07/14/22

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/14/22 (10)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

7/14/22

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/14/22

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/14/22 SD (10X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 07/11/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>5</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 6/25/2007 9:10:00 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 33109

Part Number: D206555003

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

207.11.23

Job Completion



W 07.11.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

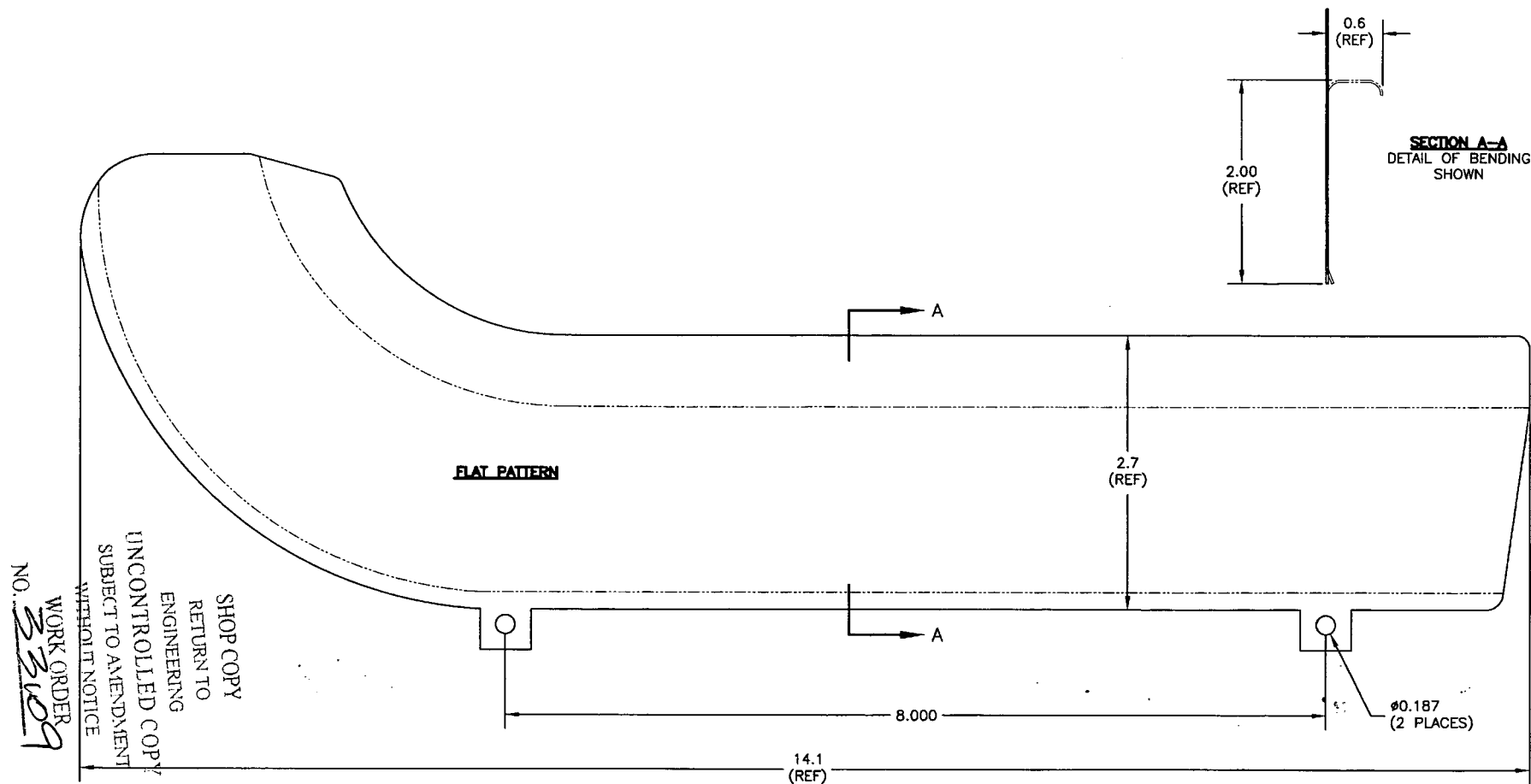
DESIGN JB	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 33109

**RELEASED**06.09.19 *[Signature]***Copyright © 1989 by DART AEROSPACE LTD**

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D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)  
D206-555-002 (BEND OPPOSITE)

#### NOTES

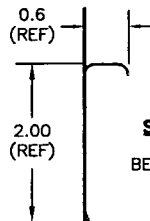
- 1) BEND PER M/F TEMPLATE D206-555-T1
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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06.09.19

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED PH	APPROVED JB	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 2 OF 7 SCALE 1:1





**SECTION C-C**  
DETAIL OF  
BENDING SHOWN

**DETAIL B**  
SCALE 1:1

REFER TO DETAIL B  
FOR 1:1 SCALE

16.000 (REF)

2.7  
(REF)

**FLAT PATTERN**

8.000

19.0  
(REF)

8.000

Ø0.187  
(3 PLACES)

**RELEASED**

06.09.19-#

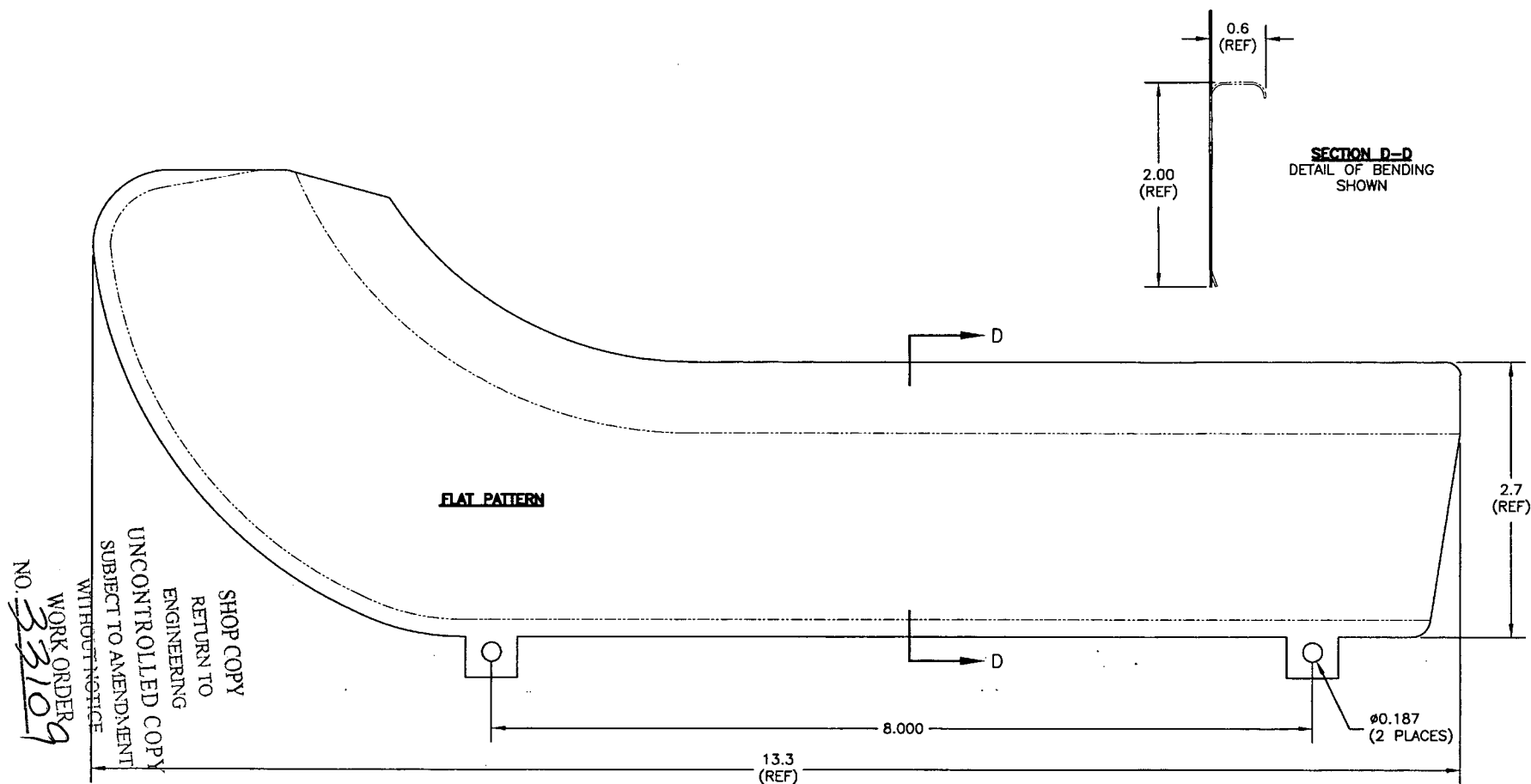
**D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)**

**D206-555-004 (BEND OPPOSITE)**

**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 3 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



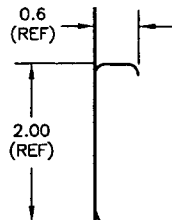
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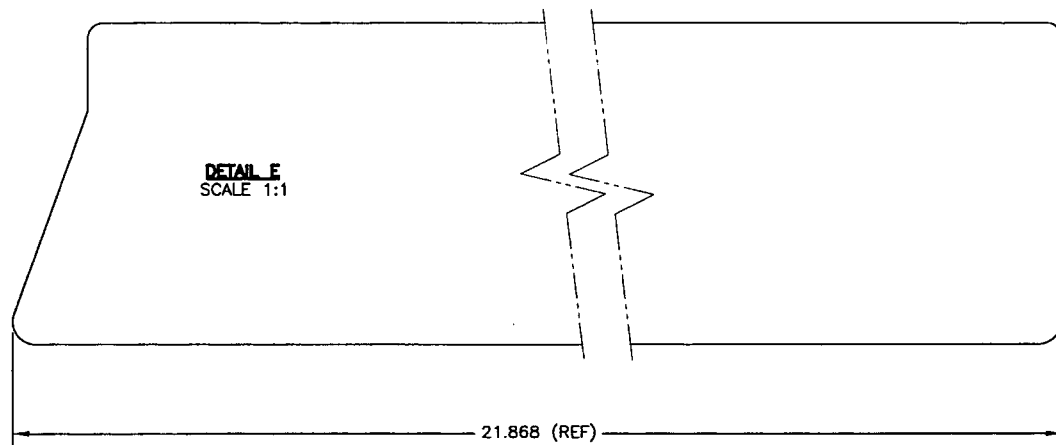
D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)  
D206-555-006 (BEND OPPOSITE)

- NOTES
- 1) BEND PER M/F TEMPLATE D206-555-T5
  - 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
  - 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	<b>DART</b> DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED PH	APPROVED JB	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 4 OF 7 SCALE 1:1

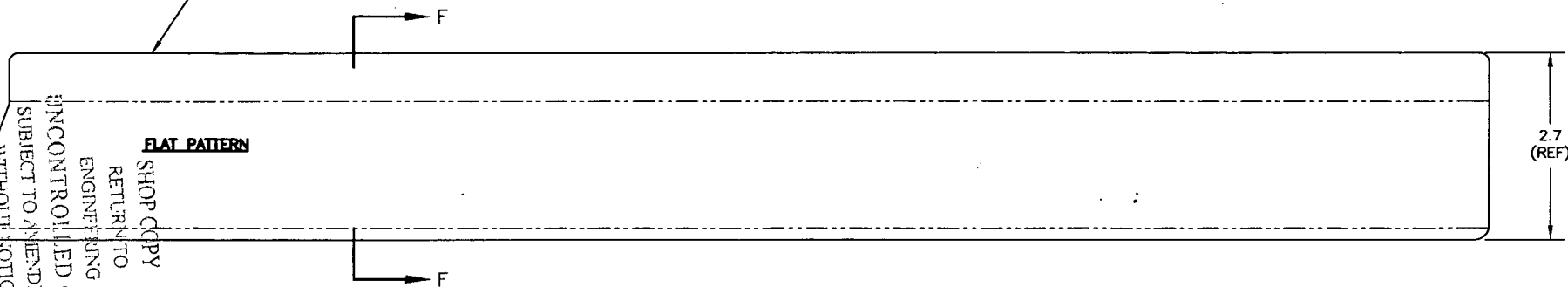


**SECTION F-F**  
DETAIL OF  
BENDING SHOWN



**DETAIL E**  
SCALE 1:1

REFER TO DETAIL E  
FOR 1:1 SCALE



**FLAT PATTERN**

NO. 37107  
WORK ORDER  
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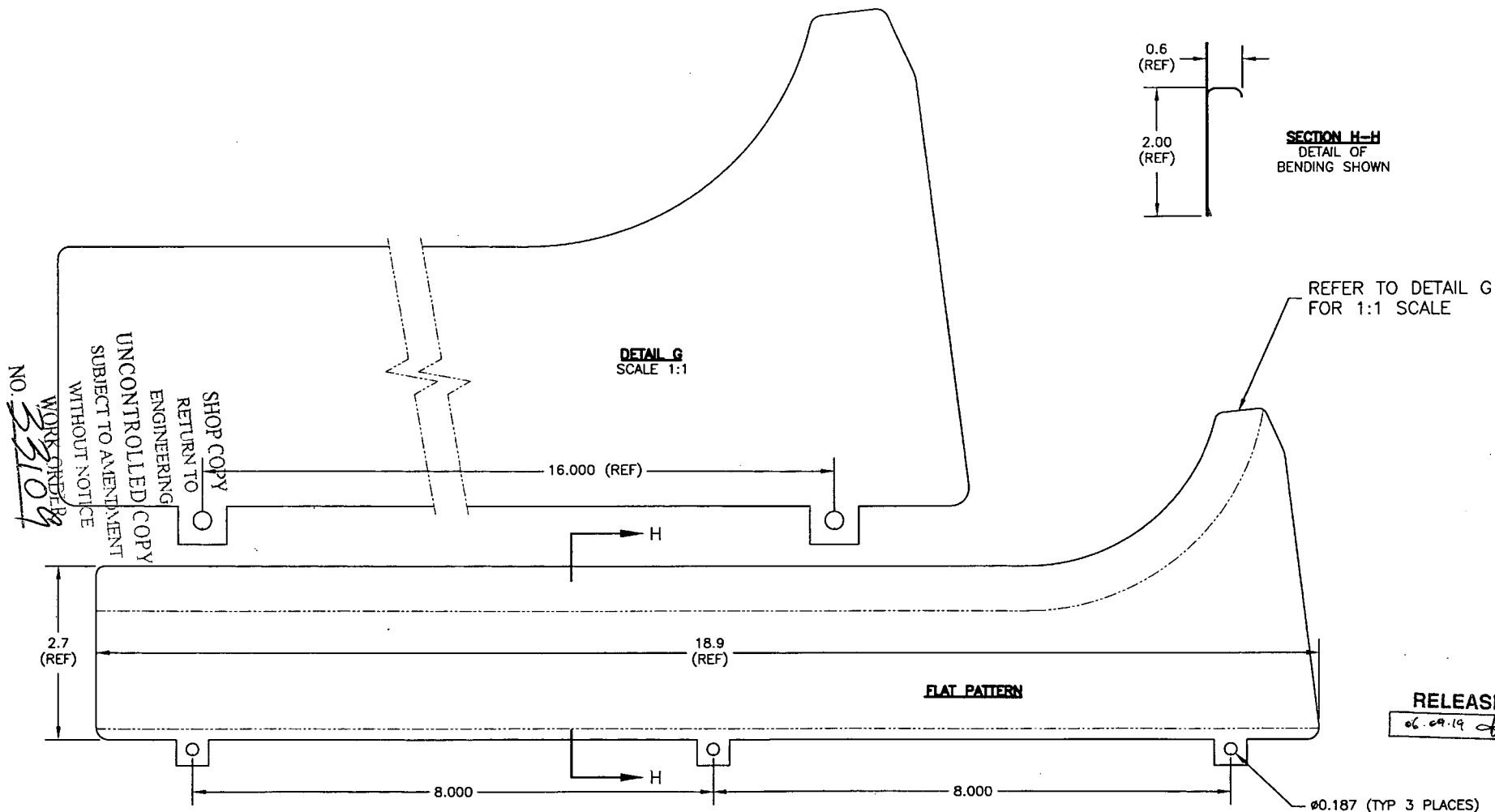
06.09.19

**D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)**

**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY [Signature]	<b>DART</b> DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED [Signature]	DRAWING NO. D206-555	SHEET 5 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



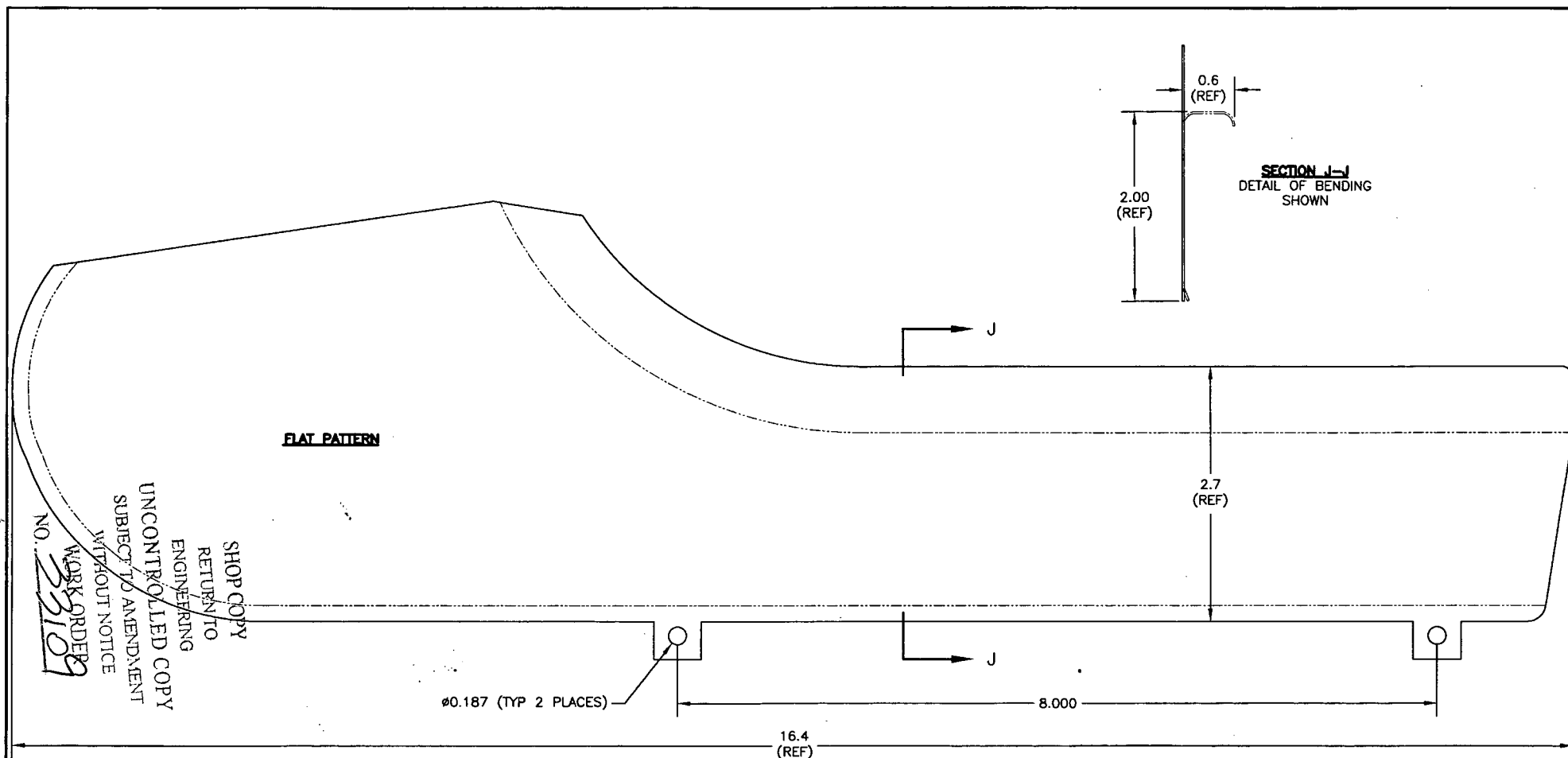
NO. 33104  
 WORK ORDER  
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 WITHOUT NOTICE

RELEASED  
 06.09.19

D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

- NOTES
- 1) BEND PER M/F TEMPLATE D206-555-T9
  - 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
  - 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY <i>[Signature]</i>	<b>DART</b> DART AEROSPACE LTD WILLOWDALE, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	SHEET 6 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 2:3



D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)  
D206-555-012 (BEND OPPOSITE)

**NOTES**

- 1) BEND PER M/F TEMPLATE D206-555-T11
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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06-09-19

DESIGN <b>JB</b>	DRAWN BY <i>[Signature]</i>	<b>DART</b> DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 7 OF 7 SCALE 1:1



## Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: November 21, 2007

1270 Aberdeen St

Hawkesbury, Ontario

No. de certificat  
Certification No.

K6A 1K7

tel.: (613) 632-5200

fax: (613) 632-1053

**C121763**

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
133024		NO. DE COM./P.O.# 5046	ELECTROPOLISH PER ASTM B912 REV.02
	4	D206-555-003 REF#B31604	
	10	D206-555-003 REF#B33109	
	10	D206-555-004 B30264 REF#B33110	

*G*  
*7/4/27*

*Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et spécifications et sont en accord avec les exigences ci-inclus.*

*We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.*

Signé pour et au nom de TQF Technologies Inc.  
Signed for and on behalf of TQF Technologies Inc.

*G. Persaud*  
T.Q.F.  
22

G. Persaud / G. McPhee

Total Quality Finishing